

**Work Order ID 85103**

Friday, June 01, 2012 4:04:23 PM

**\*85103\***

ASAP

Page 1

Item ID: PB67-43001-137

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Locking Sleeve

Start Date: 6/1/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12-06-09* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

**\*100\***

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA Rev: \_\_\_\_\_ &amp; Dwg B67-43001-1 Rev: \_\_\_\_\_

2-Deburr per dwg B67-43001-1

*CA 12619*

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*CA 12619*

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*mt 12/06/09**4*

W/O: 85103		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B-67-43001-137 PAR #: \_\_\_\_\_ Fault Category: Machin NCR: Yes No DQA: Aut Date: 12/06/28  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/06/29

NCR: 12-1545		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/28	#102	Part Chx1. Feared with dent Darin Alodin. Rc. Mat. mark / missen Darin machin + insp. hof	S asrar 12/06/28	<del>Scrap + Destroy and Replac</del> M <u>NO</u> Replac Chx1	ll 12-06-27	S 12/06/28	S asrar 12/06/28	S 12/06/28

NOTE: Date &amp; initial all entries

**Work Order ID 85103****\*85103\***

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Friday, June 01, 2012 4:04:23 PM

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**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

3 ~~14~~ 12-6-26

140

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

**\*140\***

Powdercoat

Memo

0.00

Powder Coating

\*\*\*Mask inside sleeve\*\*\*

START TIME: 3:25

OVEN TEMPERATURE: 300°

FINISH TIME: 3:55

3 ~~14~~ 12-6-26

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

5/1/2012

3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85103****\*85103\***

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Friday, June 01, 2012 4:04:23 PM

Item ID: PB67-43001-137

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Locking Sleeve

Start Date: 6/1/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: W114

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

3

d

12.06.27

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/6/27

ME  
12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 01, 2012 4:04:23 PM

Page 1

Work Order ID: 85103

Parent Item: PB67-43001-137

Parent Item Name: Locking Sleeve

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.08.29New issueKJ/JLM  
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	32.8999	0.178	0.7994737			
6061T6 RD TUBE 1.00 x .065w													

Location

MAT015

114089

116720

117983

Loc Qty

32.89988

0.3114

2

30.58848

Loc Code

SN 121619

8 pt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

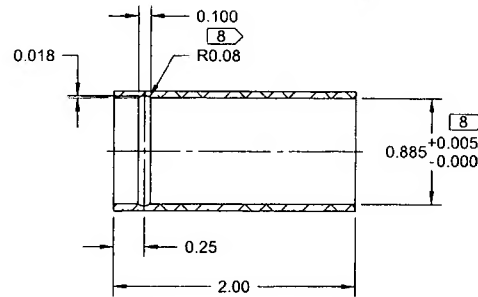
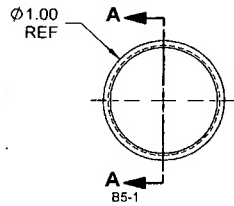
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries





**B67-43001-137 LOCKING SLEEVE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING  
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR  
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF. DART SPEC. M6061T6T1.000W.065
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) MASK INSIDE SURFACES OF LOCKING SLEEVE PRIOR TO PAINTING

#85103

RELEASED  
2009-08-24  
mnd

C	REDRAWN PREMIER AVIATION DRAWING IAW DART OSI 018 AND OSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RAW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. B67-43001-137  TITLE <b>LOCKING SLEEVE</b>	REV. C	
DRAWN			SHEET 1 OF 1	
CHECKED	JS		SCALE	
MFG. APPR.	JS		NTS	
APPROVED	JS			
DE APPR.	N/A			
DATE	09.02.27			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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